

Date: Wednesday, 2/8/2006 7:06:44 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 25730		
Estimate Number	: 11465		
P.O. Number	: N/A	Part Number	: D314091
This Issue	: 2/8/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3140 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: D
	Type : SMALL /MED FAB	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 2/15/2006
Checked & Approved By	: <u>W</u>	Qty:	2 Um: Each
Comment	: Est. A02.04.30 New Issue NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1549 sf(s)/Unit Total : 0.3098 sf(s)  
 2024-T3 .032 sheet  
 Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick  
 ( M2024T3S.032 ) 5.00" x 4.06" flat pattern ref  
 Note grain direction Batch M12758

ml 06/02/08

2

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR  
 Cut as per dwg D3140

ml 06/02/08

2

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Deburr. No sharp edges  
 Notch out .75 x .40 corner as per dwg ( -91 shown )  
 Form as per dwg ( -91 shown )

make by hand

ml 06/02/08

2

SB 06/02/13

2

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06-02-13

2

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/15

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DP Date: 01/01/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/8/2006 7:06:44 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25730

Part Number: D314091

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CY06/02/20 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ☒

CY06/02/20 (2)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

595 02/02/21

(2)

26/02/21

Job Completion



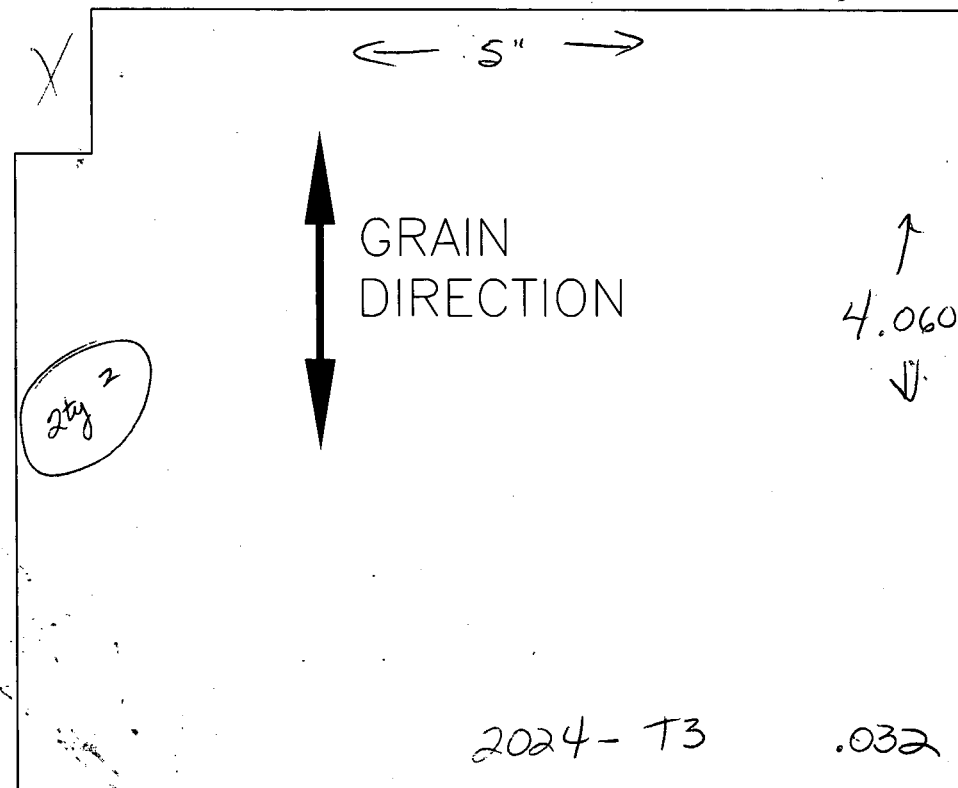
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3140-91F FLAT PATTERN  
(USE TO MAKE D3140-91/-92 DOUBLERS)

GRAIN  
DIRECTION



REFERENCE ONLY